

1. A method of forming a security article, comprising the steps of:

1 providing a light transmissive substrate having a first surface and an opposing
2 second surface, the first surface having an optical interference pattern; and
3 forming a color shifting optical coating on the second surface of the substrate,
4 the optical coating providing an observable color shift as the angle of incident light or
5 viewing angle changes.
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8 2. The method of claim 1, wherein the optical interference pattern is formed by
9 embossing a diffraction grating pattern or a holographic image pattern on the first surface of
10 the substrate.
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13 3. The method of claim 1, wherein the color shifting optical coating is formed by
14 depositing an absorber layer on the second surface of the substrate, depositing a dielectric
15 layer overlying the absorber layer and depositing a reflector layer overlying the dielectric
16 layer.
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19 4. The method of claim 1, wherein the color shifting optical coating is formed by
20 depositing a first absorber layer on the second surface of the substrate, depositing a dielectric
21 layer overlying the absorber layer and depositing a second absorber layer overlying the
22 dielectric layer.
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1 5. The method of claim 1, wherein the color shifting optical coating is formed by
2 applying a color shifting ink comprising a plurality of multilayer color shifting flakes
3 dispersed in a polymeric medium to the second surface of the substrate.
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5 6. The method of claim 1, wherein the color shifting optical coating is formed on the
6 second surface of the substrate by coextruding a color shifting material comprising a plurality
7 of multilayer optical interference flakes dispersed in a polymeric medium, with a material
8 forming the substrate.
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10 7. The method of claim 1, further comprising the steps of forming a release layer on
11 the substrate, and of hot stamping the security article to an object.
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